

Date: Friday, 24/10/2008 10:36:01 AM
User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: WEARSHOE		
Job Number	: 42926			Part Number	: D353525		
Estimate Number	: 12734			Drawing Number	: D3535 REV B		
P.O. Number	:			Project Number	: N/A		
This Issue	: 24/10/2008	S.O. No.	:	Drawing Revision	: B		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: SMALL /MED FAB	Due Date	: 05/11/2008	Qty:	16
Previous Run	: 41633			Um:	Each		
Written By	:						
Checked & Approved By	: <u>JL00810-24</u>						
Comment	: Est Rev:A New Issue 07-02-15 JLM						
	Est Rev:B As per Rev B 07-08-31 JLM			Verified By:EC			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S20GA	304/316 .040 Sheet
Comment: Qty.: 0.5355 sf(s)/Unit Total : 8.5680 sf(s) 304/316 .040 Sheet (M304S20GA)		
	Batch: 109088 # 8-10-28	
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D3535 Dwg Rev: B Prog Rev: B # 8-10-28		
	2-Deburr if necessary	# 8-10-28
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE # 8-10-28		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK S 08/08/28 X/18		
5.0	BRAKE NC	NC BRAKE
Comment: NC BRAKE 1-Form on CNC Brake as per Dwg D3535 using Jigs DT8261and DT8326 2-Form joggle on Punch as per Dwg D3535 using Jig DT8158Identify as D3535-25 SJS 08/10/30		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 24/10/2008 10:36:01 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 42926

Part Number: D353525

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/10/30 +18

7.0 POWDER COATING

POWDER COATING



M 106442

18X

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME: 9:10

220° F

OVEN TEMPERATURE: 220°

FINISH TIME: 9:40

08/10/31

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-10-31

18X

9.0 PACKAGING 1

PACKAGING RESOURCE #1



18X

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

F-P 18

m-h 08/10/31

10.0 QC21

FINAL INSPECTION/W/O RELEASE



08/11/03 JG

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-10-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

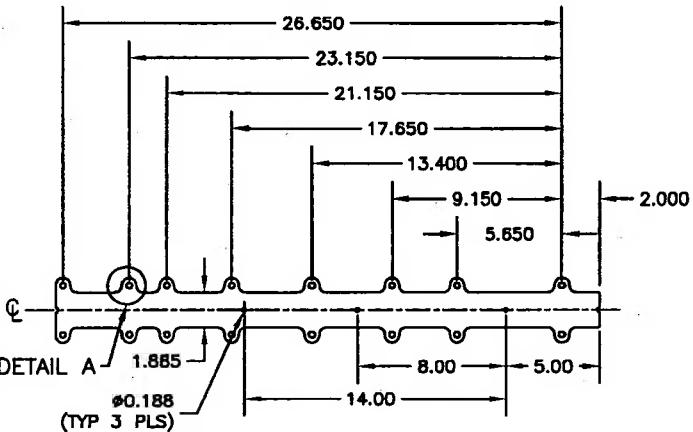
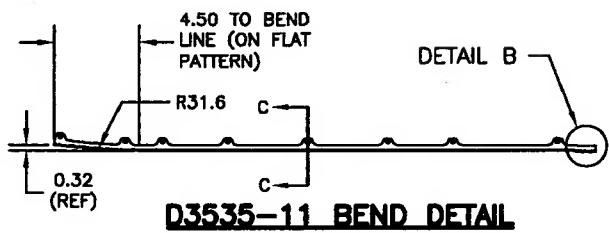
DART AEROSPACE LTD	Work Order:	42926
Description: Wearshoe	Part Number:	D3535-25
Inspection Dwg: D3535	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>BS</u>	Audited by:	<u>C</u>	Prototype Approval:	N/A
Date:	8-10-28	Date:	08/10/28	Date:	N/A

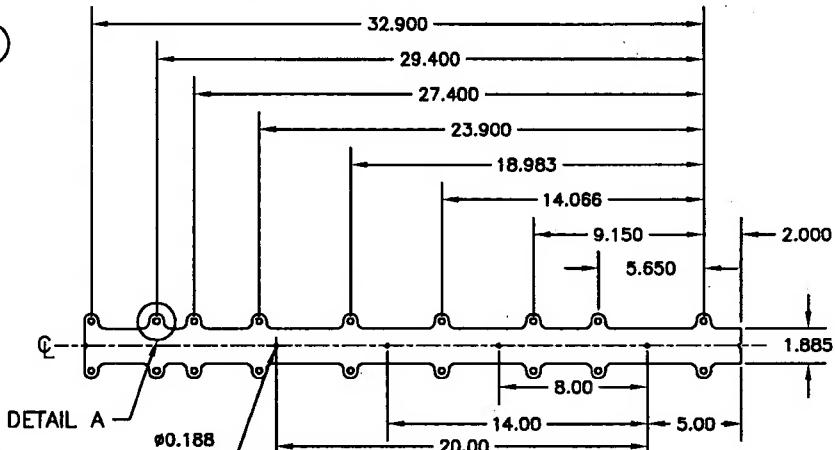
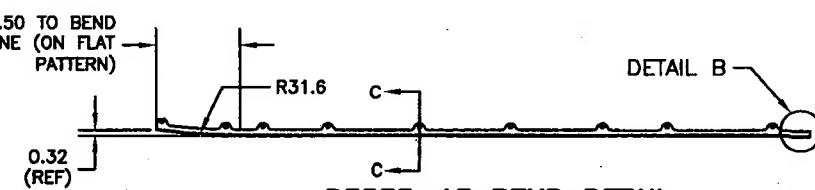
Rev	Date	Change	Revised by	Approved
A	07.11.23	New Issue	KJ/EC/DD	

DART**D3535-11F FLAT PATTERN****D3535-11 BEND DETAIL**

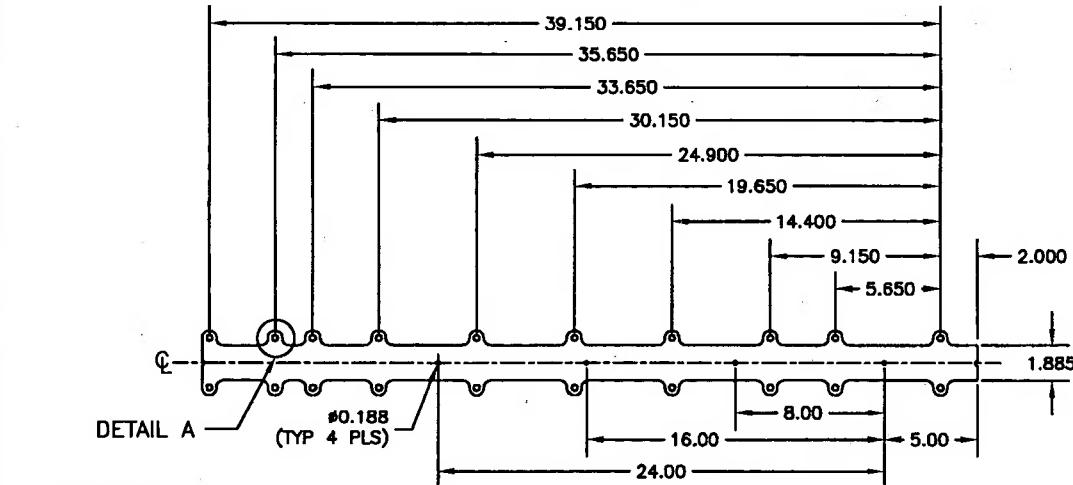
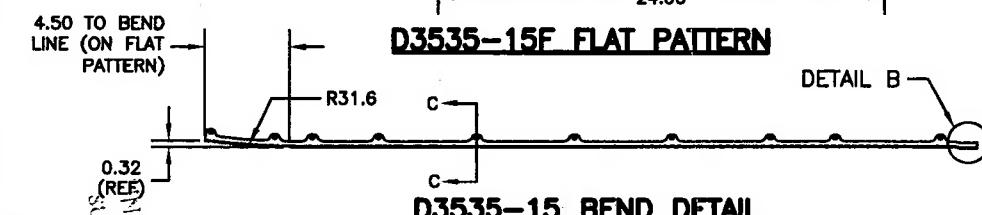
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WORK CENTER
NO. L-2000

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524.
20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER
QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT $\frac{1}{4}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT
PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

**D3535-13F FLAT PATTERN****D3535-13 BEND DETAIL**

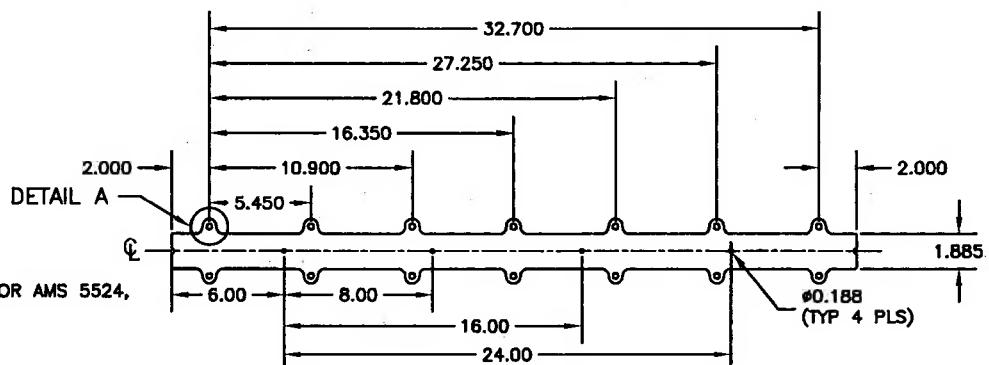
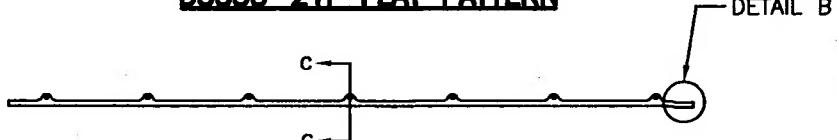
DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
C8	MH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
#	#	D3535
DATE		SCALE
07.04.17	A 06.10.25	REV. B
	B 07.04.17	SHEET 1 OF 7
		1:10
		TITLE
		WEARSHOE
		MOVE TAB OUTBOARD, ADD AMS SPEC

DARTRELEASED
07.04.24**D3535-15F FLAT PATTERN****D3535-15 BEND DETAIL**

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NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

**D3535-21F FLAT PATTERN****D3535-21 BEND DETAIL**

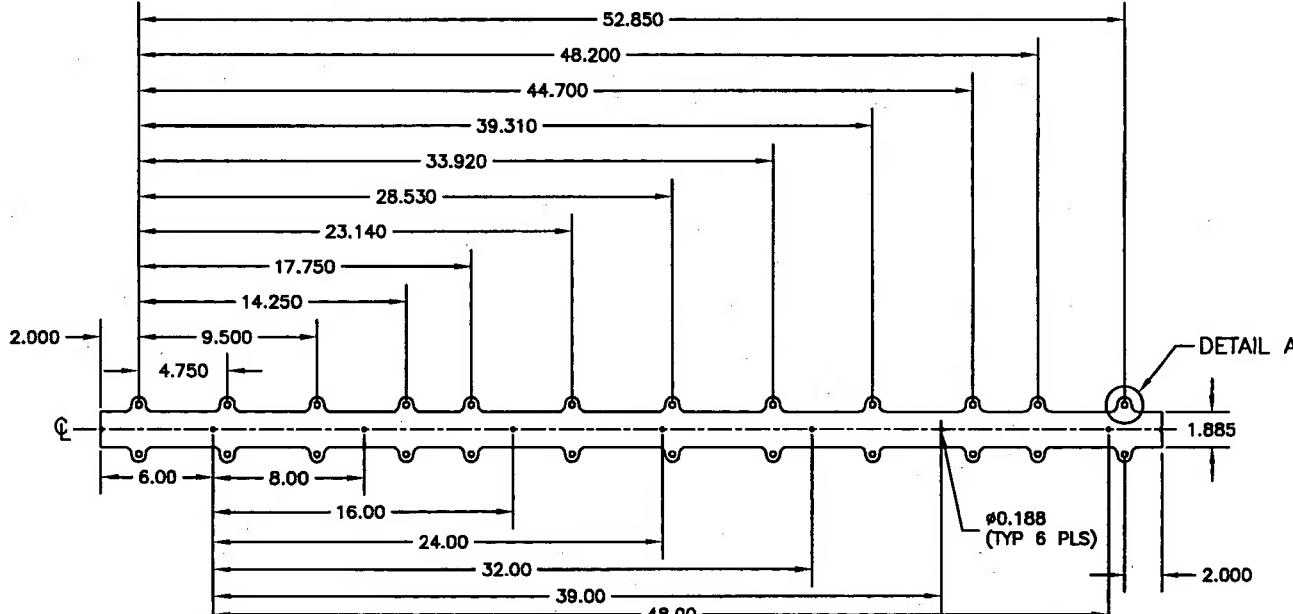
DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA	REV. B
C8	M	DRAWING NO. D3535	SHEET 2 OF 7
CHECKED	M	APPROVED	SCALE
DATE	07.04.17	TITLE WEARSHOE	1:10

DART

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CHECKED <i>MH</i>	APPROVED <i>MH</i>	DRAWING NO. D3535
DATE 07.04.17	TITLE WEARSHOE	REV. B SHEET 3 OF 7 SCALE 1:10

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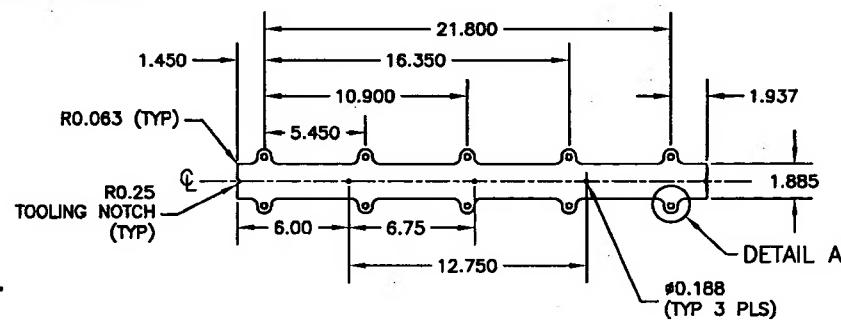
07.04.24

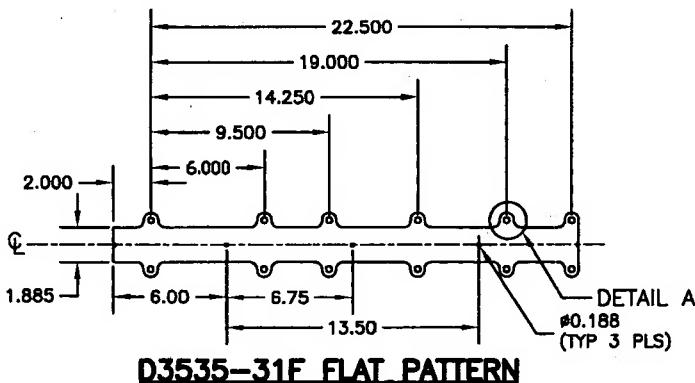
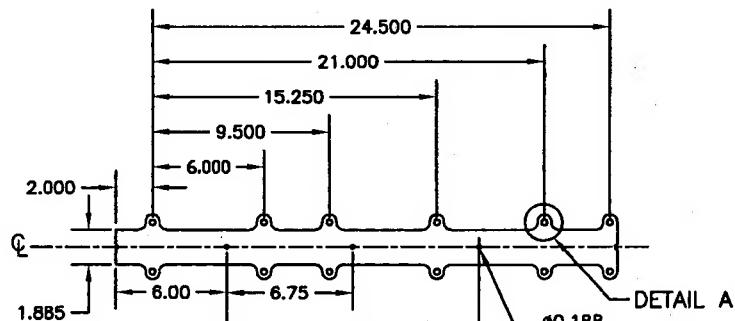
**D3535-23F FLAT PATTERN****D3535-23 BEND DETAIL**

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NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524,
20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER
QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT $\frac{1}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT
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**D3535-25F FLAT PATTERN****D3535-25 BEND DETAIL**

DART**D3535-31F FLAT PATTERN****D3535-31 BEND DETAIL****RELEASED**
07.04.17**D3535-33F FLAT PATTERN****D3535-33 BEND DETAIL**

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/	/	D3535
DATE		SHEET
07.04.17		4 OF 7
		SCALE
		1:10

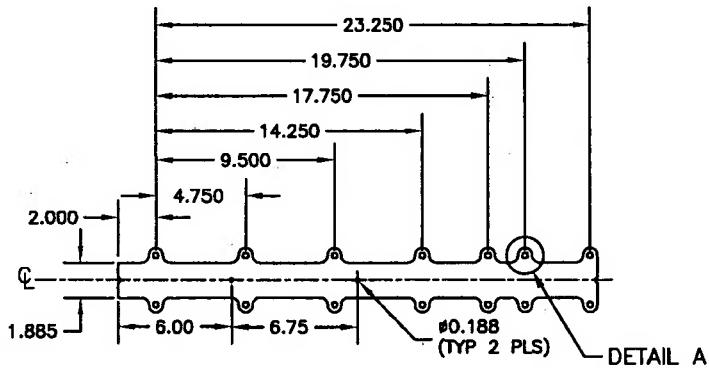
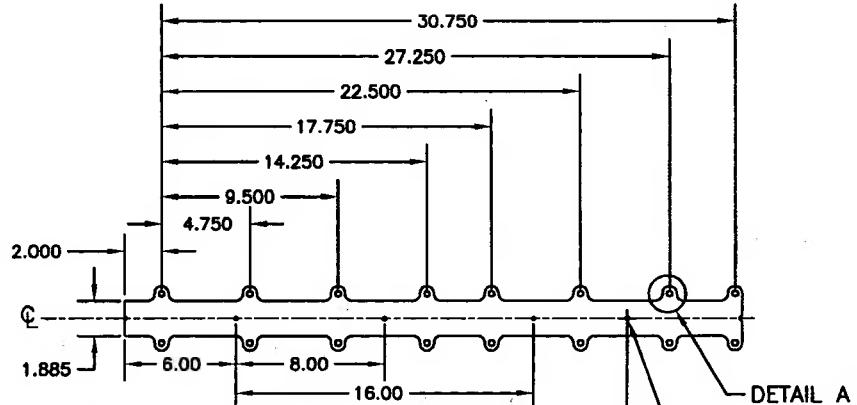
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NOTE:

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- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER
QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT
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- 8) SEE PAGE 7 FOR DETAILS AND SECTION

DARTRELEASED
07.04.17**D3535-35F FLAT PATTERN****D3535-35 BEND DETAIL****D3535-37F FLAT PATTERN****D3535-37 BEND DETAIL**

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
C.B	RH	PORT HADLOCK, WA
		SHEET 5 OF 7
		REV. B
		DATE 07.04.17
		TITLE WEARSHOE
		SCALE 1:10

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NOTES

- MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524,
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(REF DART SPEC M304S20GA)
- FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER
QSI 005 4.3
- PART IS SYMMETRICAL ABOUT $\frac{C}{2}$
- TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
- ALL DIMENSIONS ARE IN INCHES
- BREAK ALL SHARP EDGES TO 0.010 MAX
- IDENTIFY WITH DART P/N USING WHITE FINE POINT
PAINT MARKER
- SEE PAGE 7 FOR DETAILS AND SECTION

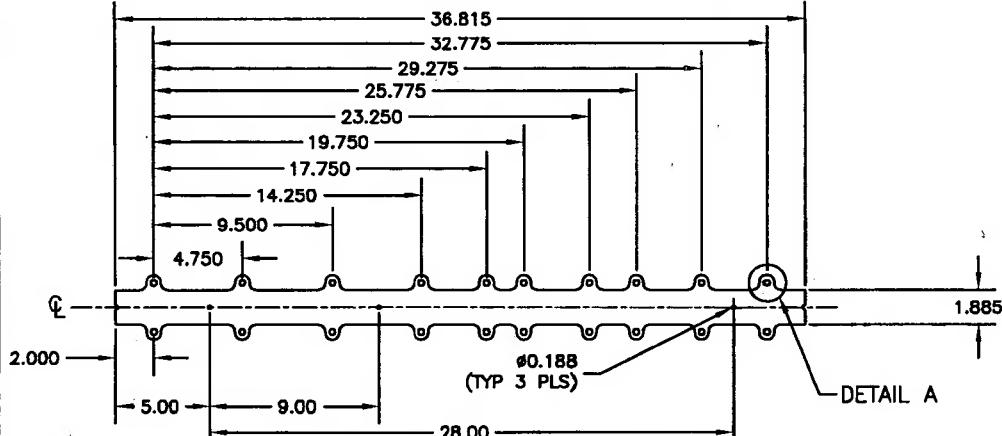
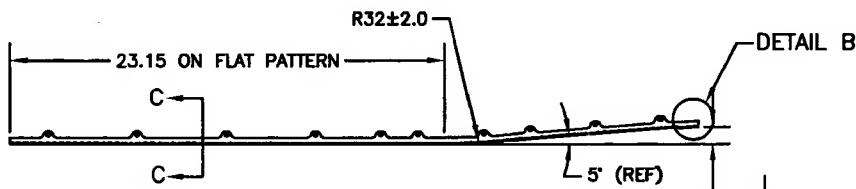
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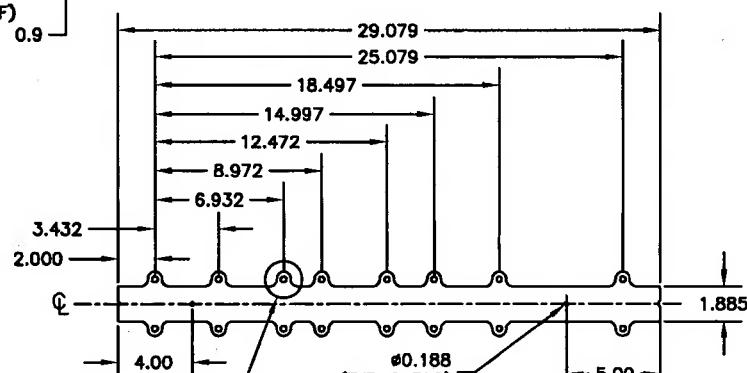
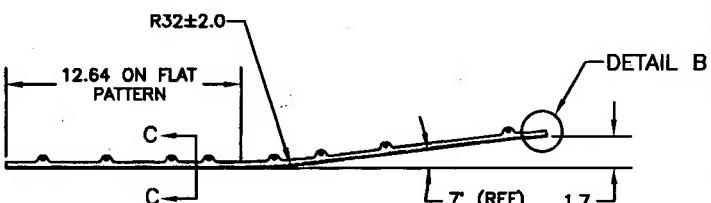
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07.04.24

**D3535-39F FLAT PATTERN****D3535-39 BEND DETAIL**

M. L. D. - D. L. S.

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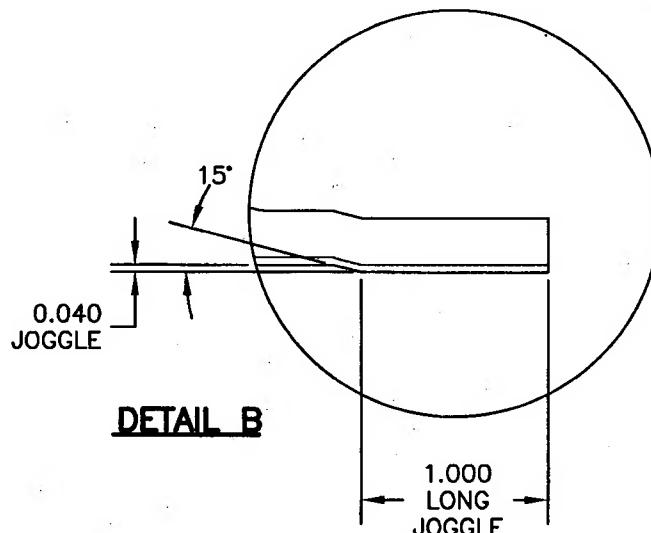
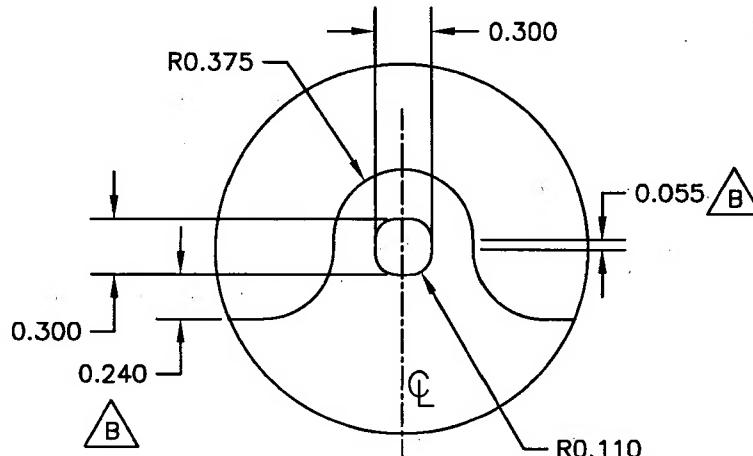
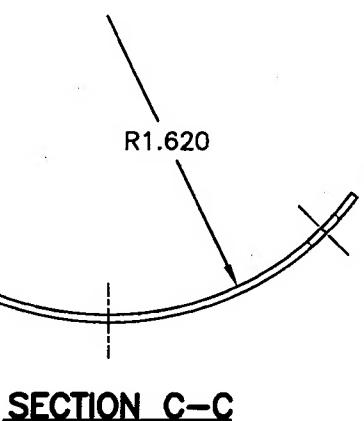
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✓	✓	D3535
DATE	TITLE	SCALE
07.04.17	WEARSHOE	1:10

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		D3535
DATE		SHEET 7 OF 7
07.04.17		SCALE
		1:1

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07.04.24

**DETAIL B****DETAIL A****SECTION C-C**

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